

# Work Order ID 50940

July 27, 2009 10:33:21 AM



Page 1

Item ID: D3957-2  
Revision ID: A-PRELIM  
Item Name: Hinge, Door RH Upper

Accept



Setup Start



Stop



Start Date: 27/07/2009 Start Qty: 2.00

Required Date: 27/07/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

**PRELIMINARY ISSUE**

Reference: *09-07-27*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_



Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

cut blank to 3.200" long

0.00

*[Signature]*

②

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA838

FOLIO REV: AA

DWG REV: A

0.00

*SB 09/07/27*

2

0

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

Work Order ID 50040








Page 3



Work Order ID 50940





Page 2

July 27, 2009 10:33:21 AM


Item ID: D3957-2 Accept  Setup Start   
Revision ID: A-PRELIM Stop   
Item Name: Hinge, Door RH Upper  
Start Date: 27/07/2009 Start Qty: 2.00  Cust Item ID:  
Required Date: 27/07/2009 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 <i>SB 09/07/27</i> 0.00							

130  QC Quality Control	QC8- Inspect parts - second check  <b>ENGINEERING APPROVAL</b> <i>Jul 28 09.07.28</i> <i>09.07.28</i>	0.00 0.00							
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(2)

140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo <i>N/A</i> <i>Jul 28 09.07.28</i>	0.00 0.00							
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50940

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <del>3257-8</del>
<b>Description:</b> Hinge		<b>Part Number:</b> 3957-2
<b>Inspection Dwg:</b> 03952 <b>Rev:</b> Prelim		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	±.030	.686	✓			
0.56	±.030	.561	✓			
0.281	±.010	.280	✓			
0.281	±.010	.280	✓			
1.250	Ref	1.256	✓			
.25	±.030	.245	✓			
.39	"	.389	✓			
.39	"	.389	✓			
.585	±.010	.585	✓			
1.170	±.010	1.170	✓			
Ø .257	+ .006 - .001	.259	✓			
0.094	±.010	.097	✓			
0.125	±.010	.126	✓			
Ø .063	+ .004 - .001	.064	✓			
Ø .391	+ .006 - .001	.394	✓			
120°	±.5°	120	✓			
3.11	±.030	3.100	✓			

<b>Measured by:</b> SP
<b>Date:</b> 09/07/27

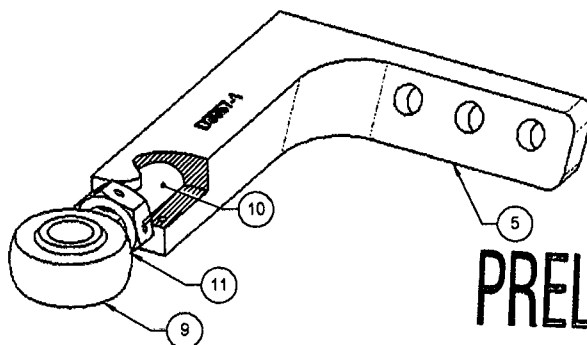
<b>Audited by:</b>
<b>Date:</b>

<b>Prototype Approval:</b> RH N/A
<b>Date:</b> 09/07/27 N/A

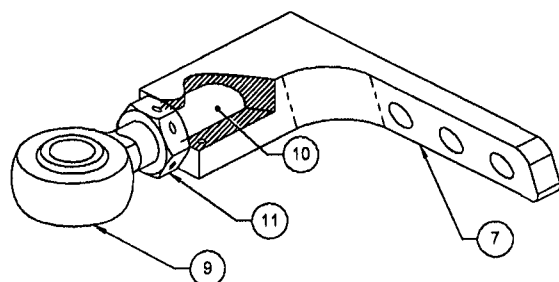
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



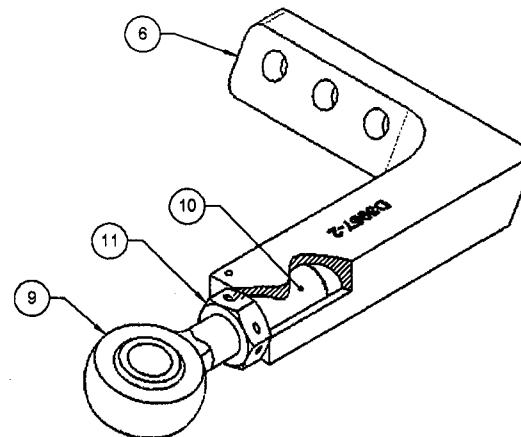
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3815-3	ROD END
10	1	1	1	1	MS124738	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



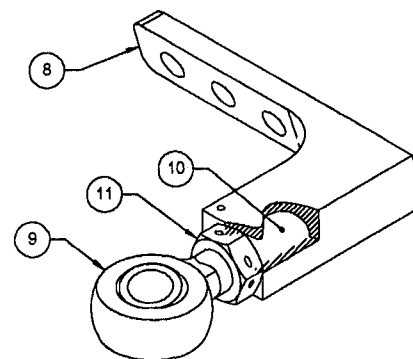
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**



**D3957-044 HINGE ASSY, DOOR RH LOWER**

**PRELIMINARY ISSUE**

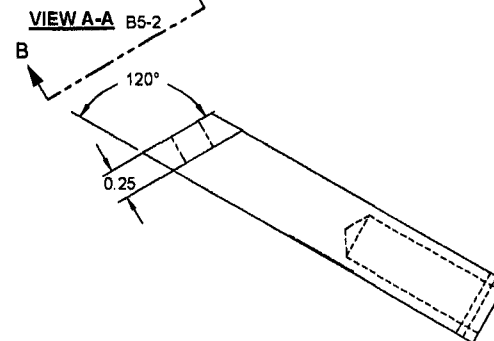
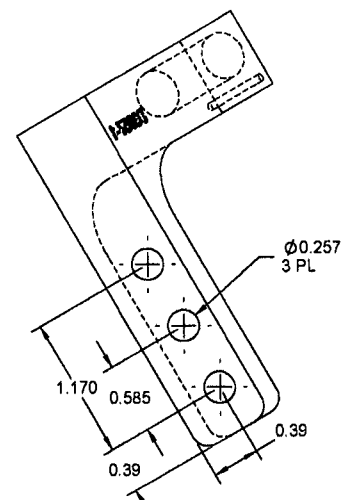
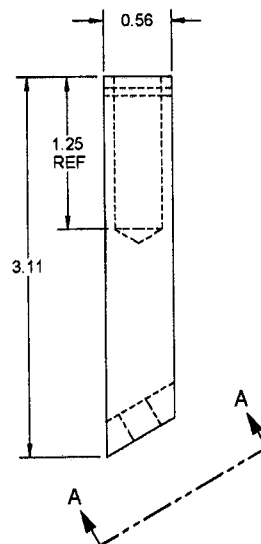
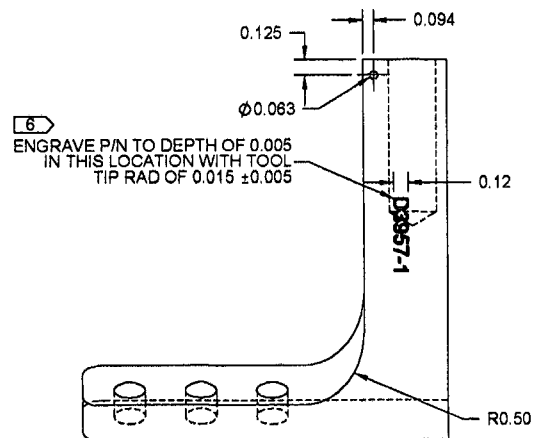
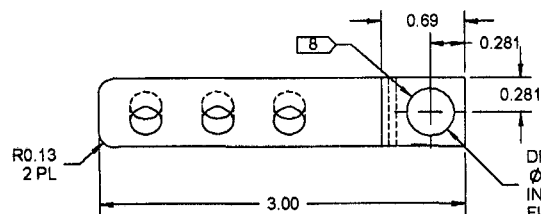
*NAF 29/10/14*

A	NEW ISSUE	09.07.20
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.07.20	

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3957** REV. A  
TITLE **HINGE** SCALE **NTS**

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**PRELIMINARY ISSUE**

*MP 09/10/14*

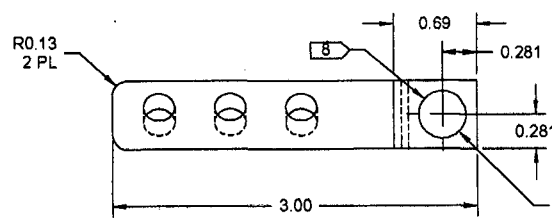
# **D3957-1 HINGE, DOOR LH UPPER**

## **NOTES:**

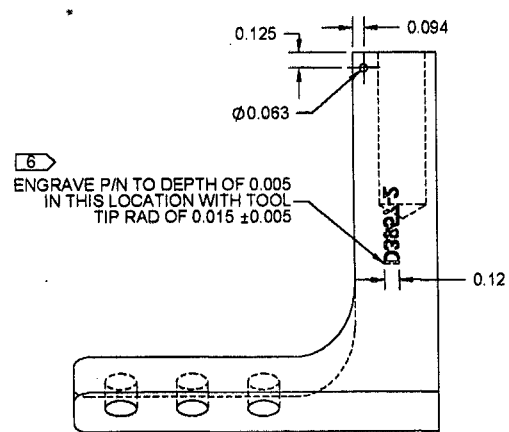
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 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	85	<b>DART AEROSPACE LTD</b>	
DRAWN	85	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	94	D3957	SHEET 2 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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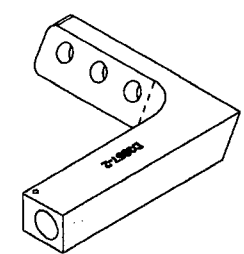
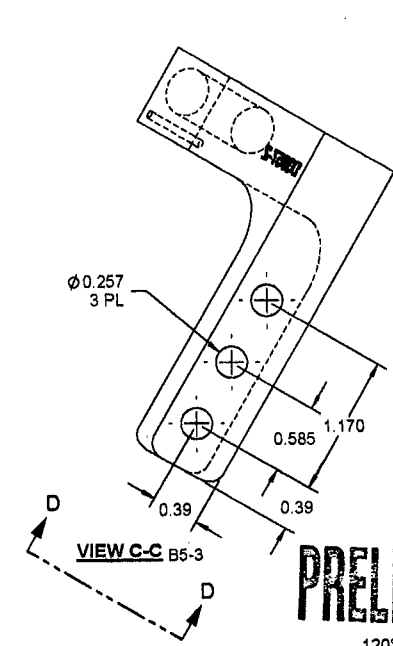
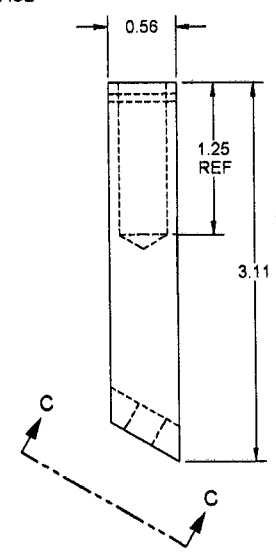
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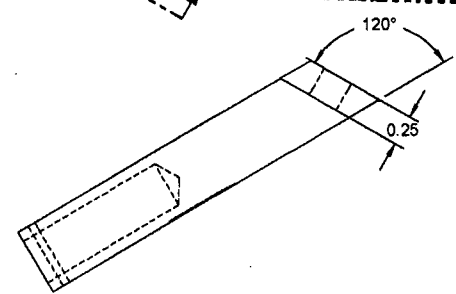
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



6  
 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



**PRELIMINARY ISSUE**  
 NP 09/10/14



**D3957-2 HINGE, DOOR RH UPPER**

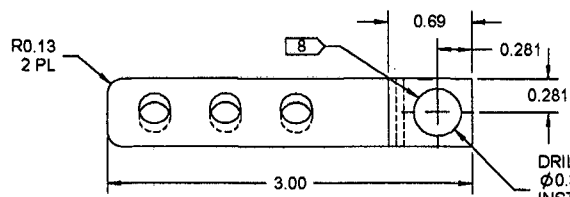
**VIEW D-D C3-3**

**NOTES:**

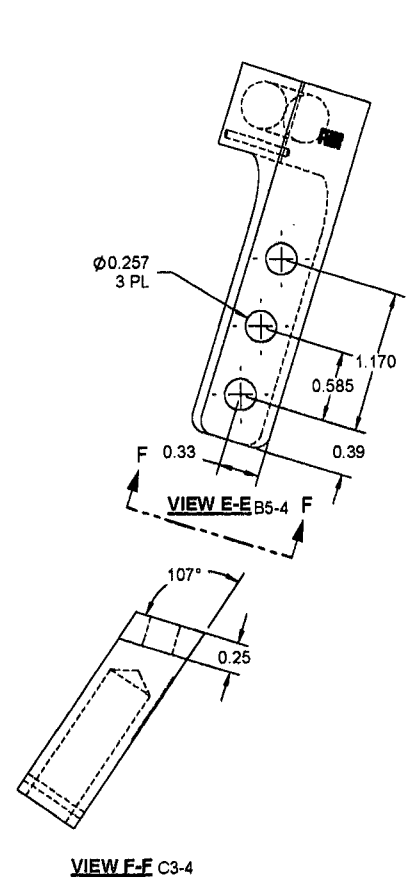
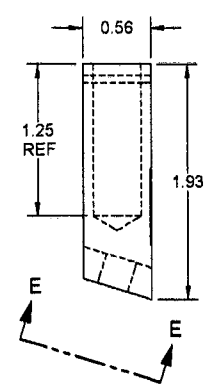
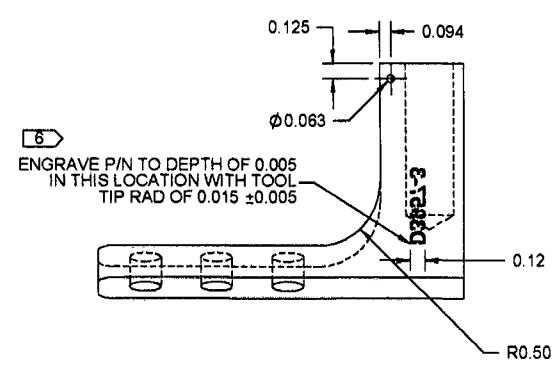
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 3 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.		HINGE	NTS
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8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



# **D3957-3 HINGE, DOOR LH LOWER**

- NOTES:**
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
  - 7) WEIGHT: 0.09 lbs
  - 8) MASK HOLE PRIOR TO POWDER COAT

09/10/14

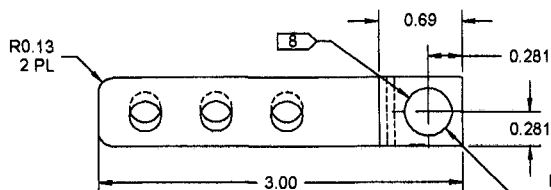
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DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 4 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



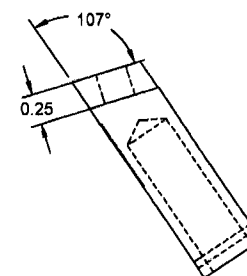
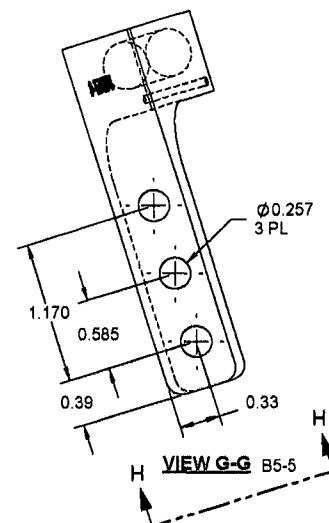
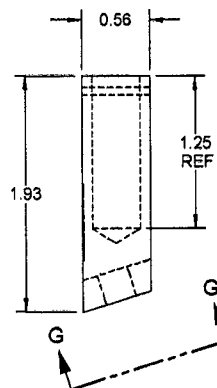
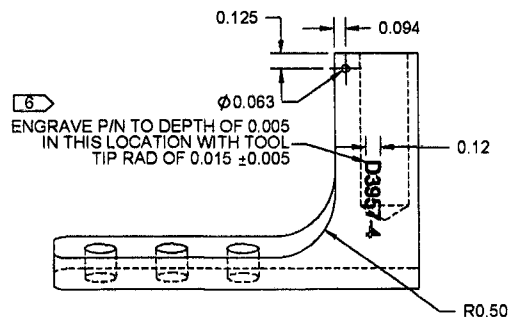
8 7 6 5 4 3 2 1

D

D



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



VIEW H-H C3-5

**D3957-4 HINGE, DOOR RH LOWER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**PRELIMINARY ISSUE**

*W 9/10/14*

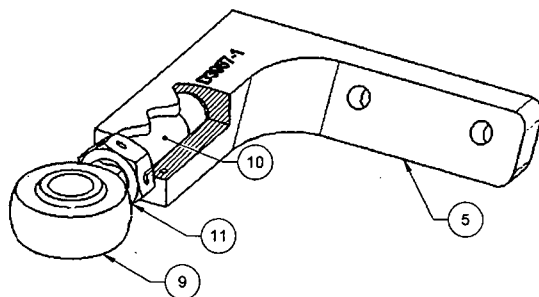
DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SA	D3957	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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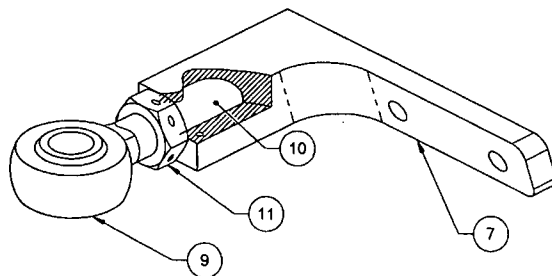
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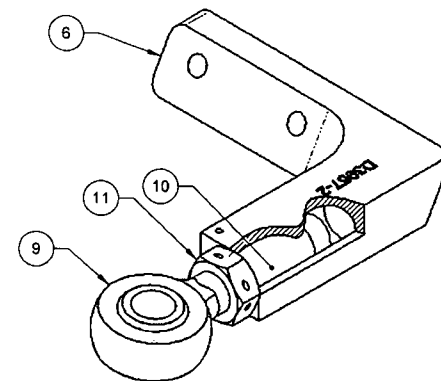
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



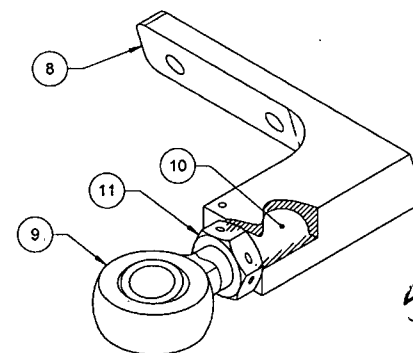
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**



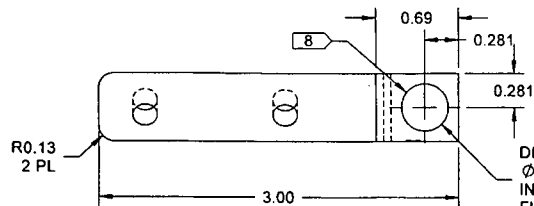
**D3957-044 HINGE ASSY, DOOR RH LOWER**

**RELEASED**  
2009-10-03  
JMD

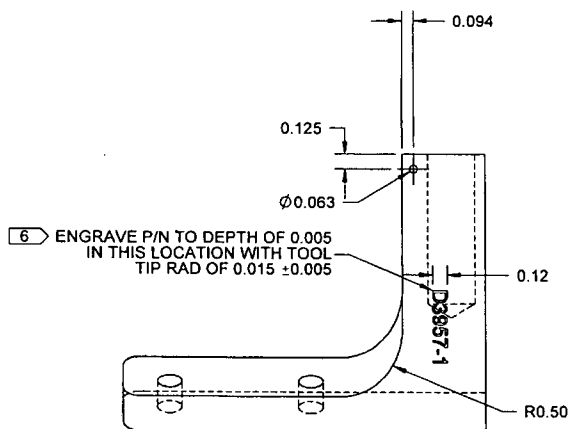
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REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3957</b>	REV. A
TITLE <b>HINGE</b>	SHEET 1 OF 5
SCALE NTS	

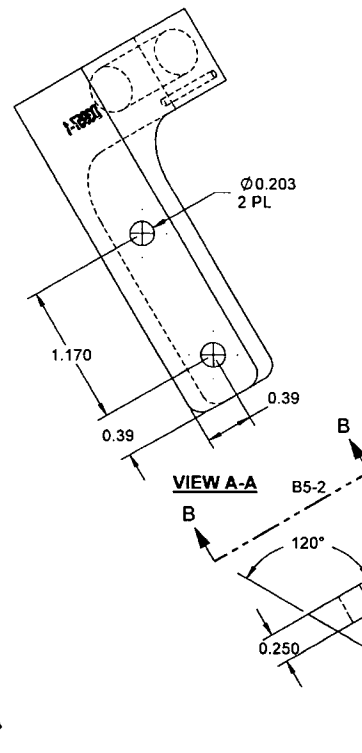
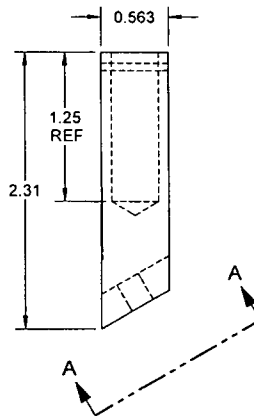
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE

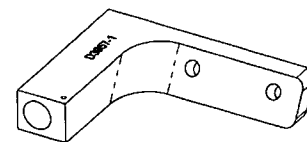


6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



VIEW A-A







VIEW B-B



D3957-1 HINGE, DOOR LH UPPER

# NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. /
MFG. APPR.		D3957	SHEET 2 OF
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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C3-2  
**RELEASED**  
 2009-10-08

50940

8

7

6

5

4

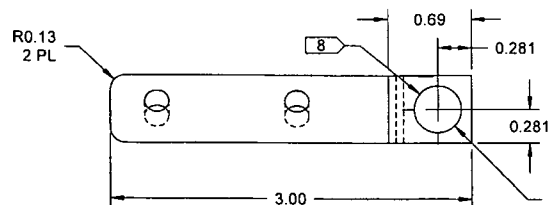
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2

1

D

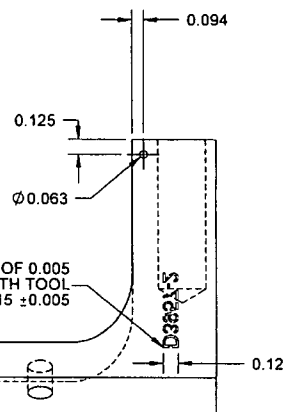
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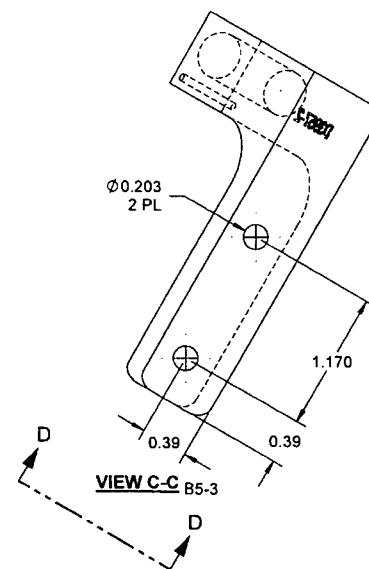
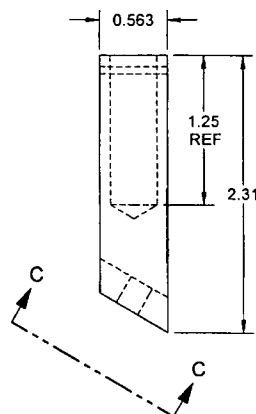
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE

C

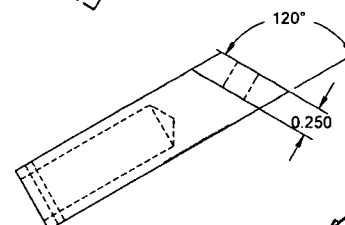
C



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



VIEW C-C  
 B5-3



VIEW D-D  
 C3-3







**D3957-2 HINGE, DOOR RH UPPER**

# NOTES:

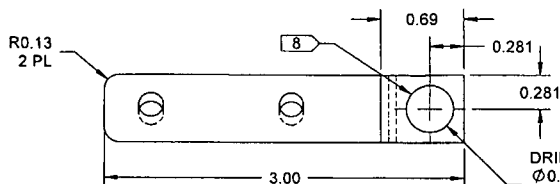
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

A

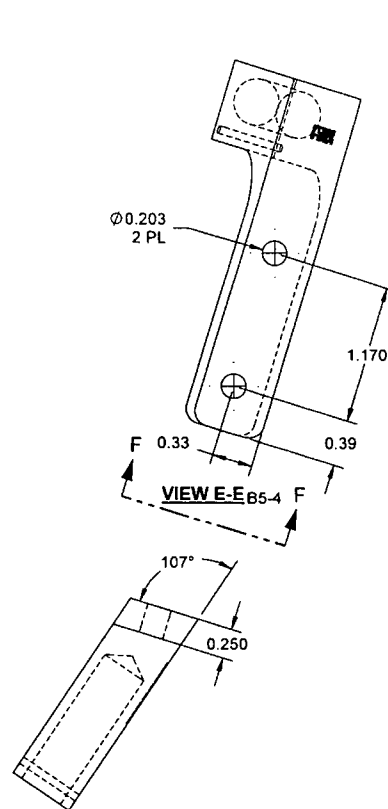
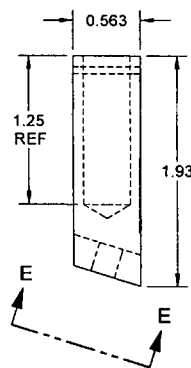
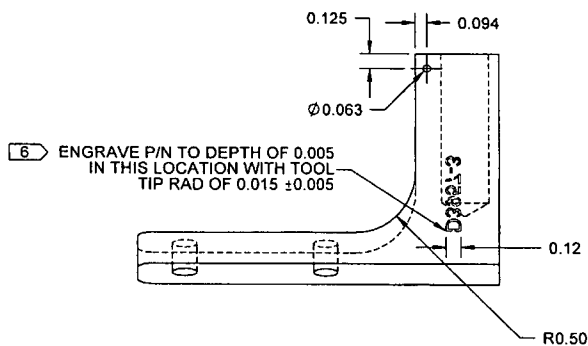
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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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 2009-10-08



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



VIEW F-F C3-4

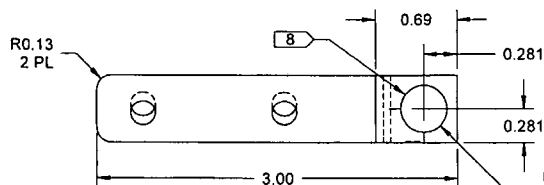
**D3957-3 HINGE, DOOR LH LOWER**

**NOTES:**

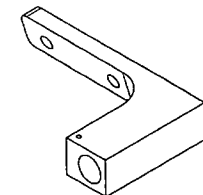
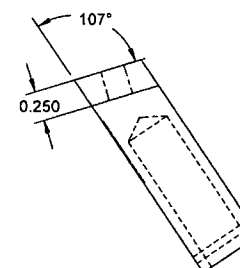
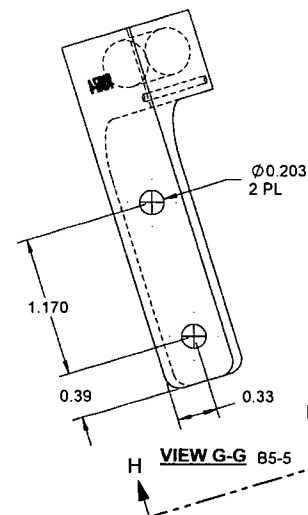
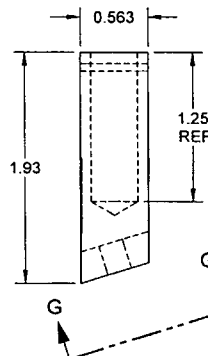
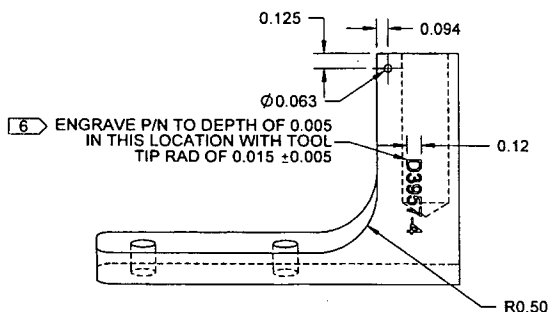
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3957	SHEET 4 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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50940  
**RELEASED**  
 2009-10-08  
*md*



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



# **D3957-4 HINGE, DOOR RH LOWER**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**RELEASED**  
 2009-10-08

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>21</i>	<b>D3957</b>	SHEET 5 OF 5
APPROVED	<i>49</i>	TITLE	SCALE
DE APPR.	<i>11</i>	<b>HINGE</b>	NTS
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